

Government of India  
Bhabha Atomic Research Centre  
Accelerator Control Division

Ref: BARC/ACnD/18/498

Date: 7.8.18

Sub: Fabrication and Supply of Nimonic Die confirming to technical specifications no: NMCDIE-18 (As per annexure 1).

Dear Sir/Madam,

1. Quotations are invited for Fabrication and Supply of Nimonic Die confirming to technical specifications no: NMCDIE-18 (As per annexure 1).
2. Bidder shall quote for deliverables as per technical specifications.
3. No Free Issue material is involved.
4. Taxes shall be quoted separately. Form AF / H whichever is applicable shall be provided, if required.
5. The quotation must reach The Head, Electromagnetic Application Section, Accelerator Control Division by 21/08/2018 (12:00 Noon) and must be sent in a sealed envelope super scribed with the reference number & the due date given above. Courier are not allowed in BARC premises, the quotation shall be sent by speed post/registered post only.
6. The address on the envelop should read: **The Head  
Accelerator Control Division,  
RCnD Bldg., North Site  
BARC, Trombay,  
Mumbai - 400 085  
(Prashant Kumar, SO/D)** *Prashant Kumar,*
7. The bidder shall complete the job within 20 weeks from the date of firm work order issued to the bidder. The finished components shall be delivered by the bidder at **Accelerator Control Division, BARC, Trombay, Mumbai - 400 085.**
8. Head, Accelerator Control Division reserves the rights to accept / reject any or all quotations without assigning any reason.
9. Delivery charges if any must be clearly mentioned in the offer. Quotation must also indicate the validity of offer. Quotation must also indicate the GST no and PAN no of the party.
10. Drawings / Sketches must be returned along with the offer.
11. The quotation has to be signed by authorized person with company seal.
12. Payment will be made by cheque only after satisfactory completion of work on production of bill, delivery challan and advance stamped receipt. It may be noted that IT @ 2% and surcharge on tax at 15% shall be deducted from your bills.
13. The interested vendors may contact: Shri Prashant Kumar, SO/D, EMAS, ACnD (Email ID: pkarn@barc.gov.in, Telephone No: 022 2559 1849/3943) for any further technical clarification.

  
(Sanjay Malhotra)  
Head, EMAS ACnD

Encl: NMCDIE-18

**Annexure 1**  
**Technical Specification**

Specification No	Revision No	Date of Issue
NMCDIE-18	0	

**Fabrication and Supply of Nimonic Die confirming to technical specifications no: NMCDIE-18 (As per annexure 1)**

**1. Scope**

The tender is invited for the Fabrication and Supply of Nimonic Die confirming to technical specifications no: NMCDIE-18 (As per annexure 1). Fabrication and qualification of complete system is in the scope of the supplier.

- a. Para 2 gives the Technical specification
- b. Para 3 gives the details of FIM
- c. Para 4 gives the brief description of the job
- d. Para 5 gives the Reference Drawing
- e. Para 6 gives the Vendor's qualification
- f. Para 7 Deliverables
- g. Para 8 gives the General Specifications

**2. Technical Requirements**

The material of construction of Die is made out of Nimonic Grade 90. The supplier must purchase forged material to avoid any internal flaws. To ensure this, Ultrasonic testing report is envisaged to be produced by supplier. Furthermore, machining of sub-components involved very tight tolerances so it is strictly recommended to follow the wire cut operation. The drawing contains all details of the sub-components is enclosed at the end of this document. After approval of the fabrication drawing by purchaser machining should start. All fabricated components shall be qualified on CMM having better than 5microns accuracy.

**3. Free Issue Material**

No free issue material is involved. All raw materials are in scope of supplier's scope.

**4. Brief description of the job**

- a) Supplier shall make fabrication drawings and get them approved by the purchaser before initiating the fabrication.
- b) Material of Construction: **Nimonic Grade 90.**

**5. Reference Drawing**

S.No	Item Description	Drawing No
1	Details of Nimonic Assembly	A3-A00VTCA22

**6. Vendor's qualification**

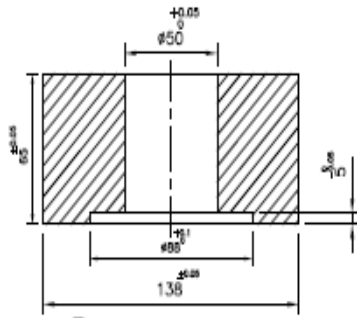
1. Supplier shall have in-house facility for carrying out fabrication and qualification of the components. Sub-contract is not permissible.
2. The raw material shall be purchased along with the material test report particularly ultrasonic test report before commencing fabrication.

**7. Deliverables**

S. No	Items	Qty.
1	Side Ring	05 No
2	Bottom Ring	05 No
3	Ejecting Plunger	05 No
4	Plunger	05 No
5	Central Hole	05 No
6	Base Ring	05 No
7	Bottom Bush	05 No

**8. General Specifications**

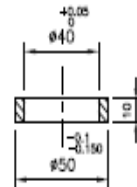
- i) Supplier shall enclose the complete specifications and compliance statement of the product being offered with the offer, without which the offer will be liable for rejection.
- ii) Overall cost will be compared and should include packaging, forwarding, and safe delivery to BARC stores.



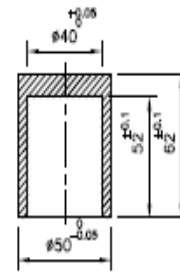
01 SIDE RING  
QTY. : 5 NOS.  
MATL : NIMONIC



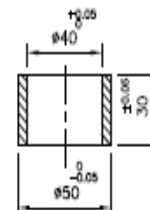
02 BOTTOM BUSH  
QTY. : 5 NOS.  
MATL : NIMONIC



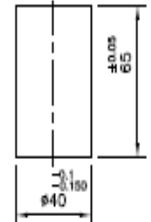
02 BOTTOM R I N G  
QTY. : 5 NOS.  
MATL : NIMONIC



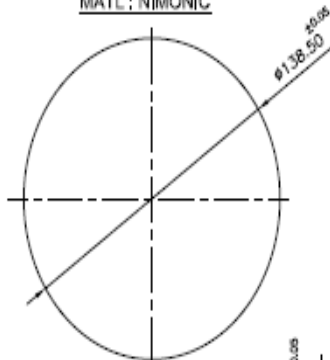
EJECTING PLUNGER  
QTY. : 5 NOS.  
MATL : NIMONIC



04 PLUNGER  
QTY. : 5 NOS.  
MATL : NIMONIC



05 CENTRAL POLE  
QTY. : 5 NOS.  
MATL : NIMONIC



06 BASE R I N G  
QTY. : 5 NOS.  
MATL : NIMONIC

TITLE- <b>DETAILS OF NIMONIC ASSEMBLY</b>				APP'D.
				SCALE <b>1:1</b>
PROJECT				ALL DIMENSIONS ARE IN mm
REV. DATE				REV. DATE 24.11.2016
DES'D.				DRG. No.
DES'N				A3-400VCA22
GOVERNMENT OF INDIA BHABHA ATOMIC RESEARCH CENTRE ACCELERATOR CONTROL DIVISION.				SH 1 OF 1 DATE

REV	DATE	CHANGE	BY	CHK'D

CLASS OF TOLERANCE	ADTIC	ADTIC EXCLUDING	ADTIC	ADTIC	ADTIC
	0.5	0	0	0.1	0.05
	3	0	0	0.15	0.075
	10	0	0	0.2	0.1
	30	0	0	0.25	0.125
	100	0	0	0.3	0.15
	315	0	0	0.35	0.175